Work Order ID 120384

Wednesday, June 04, 2014 3:03:36 PM

120384

Item ID: D2565-105 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Strut

Start Date: 6/04/14 **Start Qty:** 6.00 *6*

Required Date: 6/04/14 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 14-06-06 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2565	Rev E								
100	NC BRAKE	0.00			DAS 30 9-89	6			14/06/09
100									
Brake NC	**Memo**	0.00							
Brake NC	Punch as per Dwg D2565 usingDT 8313								
110	Small Fab	0.00							DAS 36 9-89
110						6x			14/06/26
Small Fab	**Memo**	0.00							
Small Fab	Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00			DAS 27 9-89	6			
120									
QC	**Memo**	0.00			14/6/26				
Quality Control									

QA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D2565-105 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Strut

Start Date: 6/04/14 **Start Qty:** 6.00 *6*
Required Date: 6/04/14 **Req'd Qty:** 6.00 *6*
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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
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Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005-4.3-Steel	0.00				6	0	14-7-2	DAS 9-89
130									
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 1025 2/60° OVEN TEMPERATURE: FINISH TIME: 1055								
140	QC3- Inspect Part Finish	0.00				6			
140									
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location	0.00				6x		14-7-3	SP
150									
Packaging	**Memo**	0.00							
Packaging									

DAS 27 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

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Suspected Unapproved ☐

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Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
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☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D2565-105 **Accept** *N9000401100* **Setup Start** *NS1*
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Required Date: 6/04/14 **Req'd Qty:** 6.00 *6* **Customer:**
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Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MCJ 14-07-04

14-7-3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data	☐									
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☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Wednesday, June 04, 2014 3:03:36 PM

Work Order ID: 120384 *120384*

Parent Item: D2565-105 *D2565-105*

Parent Item Name: Strut

Start Date: 6/04/14 **Required Date:** 6/04/14

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	791.7261	1.6825	11			

M304TR0.750W.049

304 RD Tube .750 x .049W

**

68-6 30 DAS

14/06/09

Location	Loc Qty	Loc Code	
MAT017	791.7261		
122312	4.04		
124768	49.27		
M126183	25.4399		
M128084	44.9762		
M129188	268		13
M129363	400		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Part No. _____

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Handling/Pre	☐									
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Operator	☐									
Offset/Setup	☐									
Process	☐									
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Training	☐									
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- ☐ Temperature/Cure
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DART AEROSPACE LTD

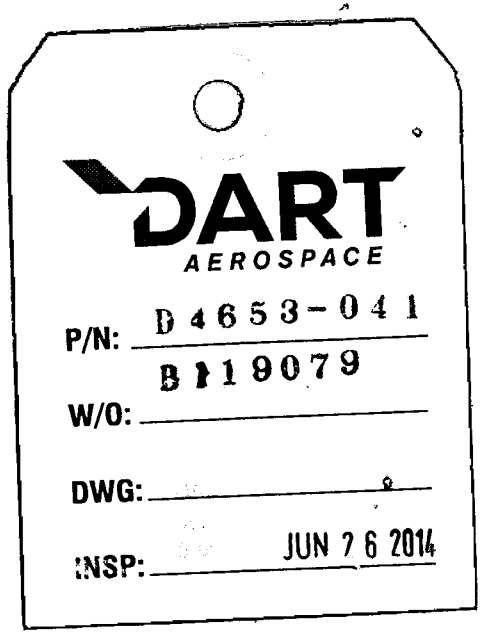
Description: Stub | Work Order: 120384

Inspection Drawing: D256 | Rev: E | Part Number: D256-105

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.19	+/-.030	20.20	✓		T	SB-5
19.39	+/-.030	19.40	✓		T	SB-5
Ø.316	+/-.005					

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*
DAS 30 9-89	DAS 36 9-89	DAS 27 9-89	
Date 14/06/09	Date 14/06/09	Date 4/6/26	Date


DART
AEROSPACE
P/N: D4653-041
B119079
W/O:
DWG:
INSP: JUN 26 2014